

Date: Tuesday, 7/10/2007 1:05:51 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARPAD
Job Number	33455		
Estimate Number	12785		
P.O. Number	N/A	Part Number	D356411
This Issue	7/10/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3564 REV C
First Issue	N/A	Project Number	N/A
Previous Run	N/A	Drawing Revision	C
Written By		Material	N/A
Checked & Approved By		Due Date	7/17/2007
Comment	Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM	Qty:	20 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 063 Sheet 
		Comment: Qty.: 0.9177 sf(s)/Unit Total : 18.3540 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <del>HB 07-07-11</del> M104725 HB 07-07-11
2.0	WATER JET	FLOW WATER JET 
		Comment: FLOW WATER JET 1-Cut as per Dwg D3564 *****(D3564-1F)***** Dwg Rev: C Prog Rev: C 2-Deburr if necessary -> SAD 07/07/13 HB 07-07-11
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  HB 07-07-11
4.0	QC8	SECOND CHECK  Counted SAD 07-07-12 (22)
5.0	BRAKE NC	NC BRAKE  Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8139 and DT 8155 SAD 07/07/17 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 02/07/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/10/2007 1:05:51 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33455

Part Number: D356411

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

Ex 07/07/17 X20

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch  
A/R 2059B Hardcoat M104463 M105058

Weld hardcoat as per Dwg D3437

8804107124 X20

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DD 07-07-25 60

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ex 07/07/05 X20

10.0 POWDER COATING

POWDER COATING



M 104 846

X20

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BR/F/07-07-26

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M.F.

07/07/06

X20

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0 PACKAGING 1

PACKAGING RESOURCE #1



X20

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-14

M.F.

07/07/26

13.0 QC21

FINAL INSPECTION/W/O RELEASE



X20

Comment: FINAL INSPECTION/W/O RELEASE

Ex 07/07/27

Job Completion



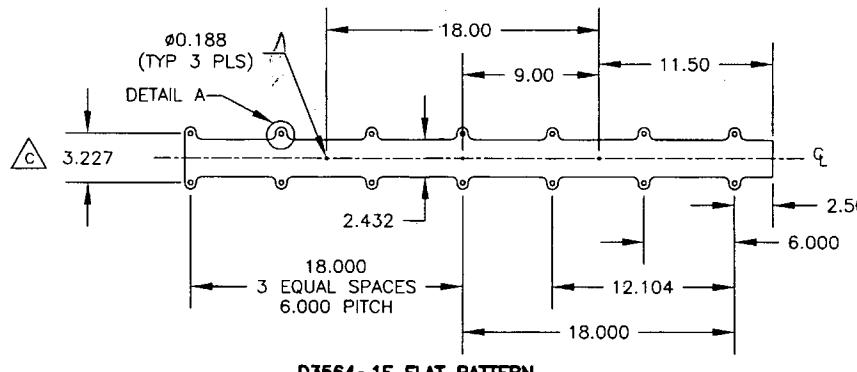
IN SPOT IT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

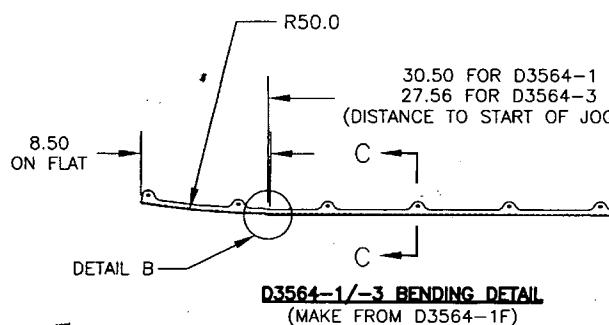
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

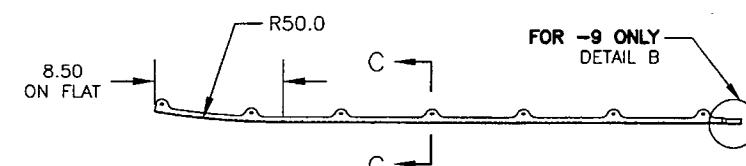
NOTE: Date & initial all entries



**D3564-1F FLAT PATTERN**



**D3564-1/-3 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-9/-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308



**D3564-1/-3/-9/-11 WELDING DETAIL**

WORK ORDER NO 2345  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

**D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES**

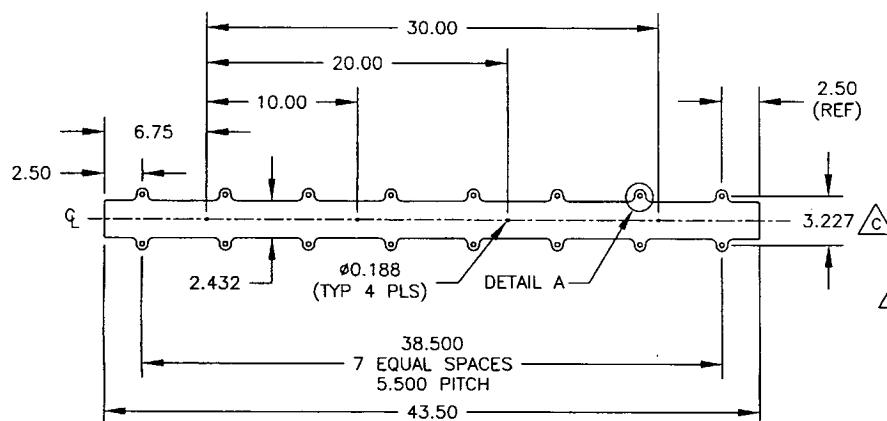
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

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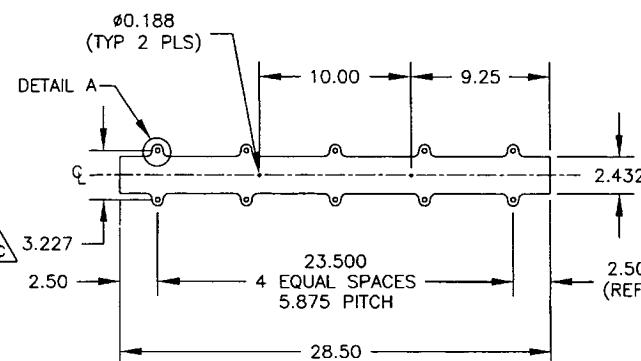
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C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWTHORPE, ONTARIO, CANADA
CHECKED <input checked="" type="checkbox"/>	APPROVED <input checked="" type="checkbox"/>	DRAWING NO. D3564
DATE 07.04.17	TITLE WEARSHOE	REV. C SHEET 1 OF 2 SCALE 1:8

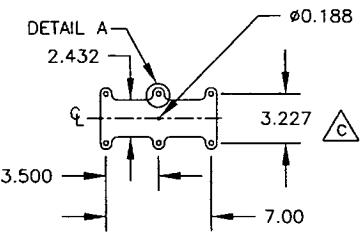
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07.04.28 #



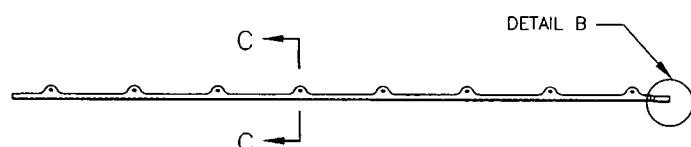
**D3564-5F FLAT PATTERN**



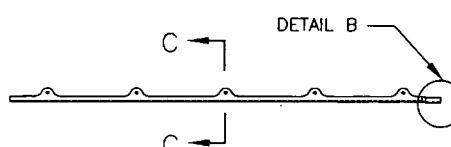
**D3564-7F FLAT PATTERN**



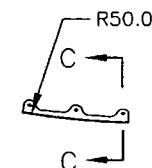
**D3564-13F FLAT PATTERN**



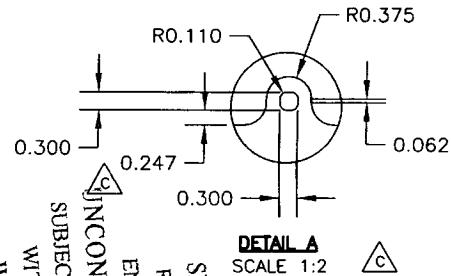
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



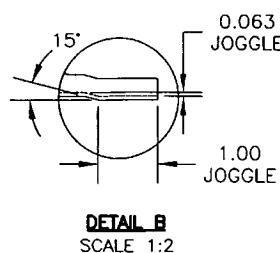
**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



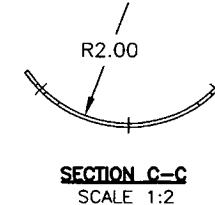
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



NO. 3  
WORK ORDER  
RETURN TO  
ENGINEERING  
INCONTROLLED COPY  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT



**DETAIL B**  
SCALE 1:2



**SECTION C-C**  
SCALE 1:2

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DESIGN	DRAWN BY	<b>DART</b>
CHECKED	APPROVED	DRAWING NO.
#	#	D3564
DATE	TITLE	REV. C SHEET 2 OF 2 SCALE 1:8
07.04.17	WEARSHOE	

**RELEASED**  
07.06.2011

DART AEROSPACE LTD	Work Order:	33455
Description: WEAR PAD	Part Number:	D 3564-11
Inspection Dwg:	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## **First Article**      **Prototype**

Measured by:	HB	Audited by:	SJ	Prototype Approval:	N/A
Date:	67-67-11	Date:	26/07/12	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	